

Date: Tuesday, 20/05/2008 12:44:42 PM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 39346		Part Number	: D37933		
Estimate Number	: 13315		Drawing Number	: PRELIM		
P.O. Number	:		Project Number	: N/A		
This Issue	: 20/05/2008 S.O. No. :		Drawing Revision	: PRELIM		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 27/05/2008 Qty: 2 Um: Each		
Previous Run	: 39278					
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:A 08-05-03 new issue DD verified by:EC					

## Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		Comment: Qty.: 1.3545 sf(s)/Unit Total : 2.7090 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: 107909 QB 8-5-20
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3793 Dwg Rev: PFE Prog Rev: PFE QB 8-5-20 NEW .DXF D3793-3 UPDATED
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		IB 8-5-20
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		QC 25 prototype only
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		NC BRAKE
		Comment: NC BRAKE 1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39346

Part Number: D37933

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5



INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME: \_\_\_\_\_

N/A

08.05.22

OVEN TEMPERATURE: \_\_\_\_\_

NOT FOR STOCK

FINISH TIME: \_\_\_\_\_

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

08.05.22  
STOCK AS PROTOTYPE

Location: \_\_\_\_\_

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

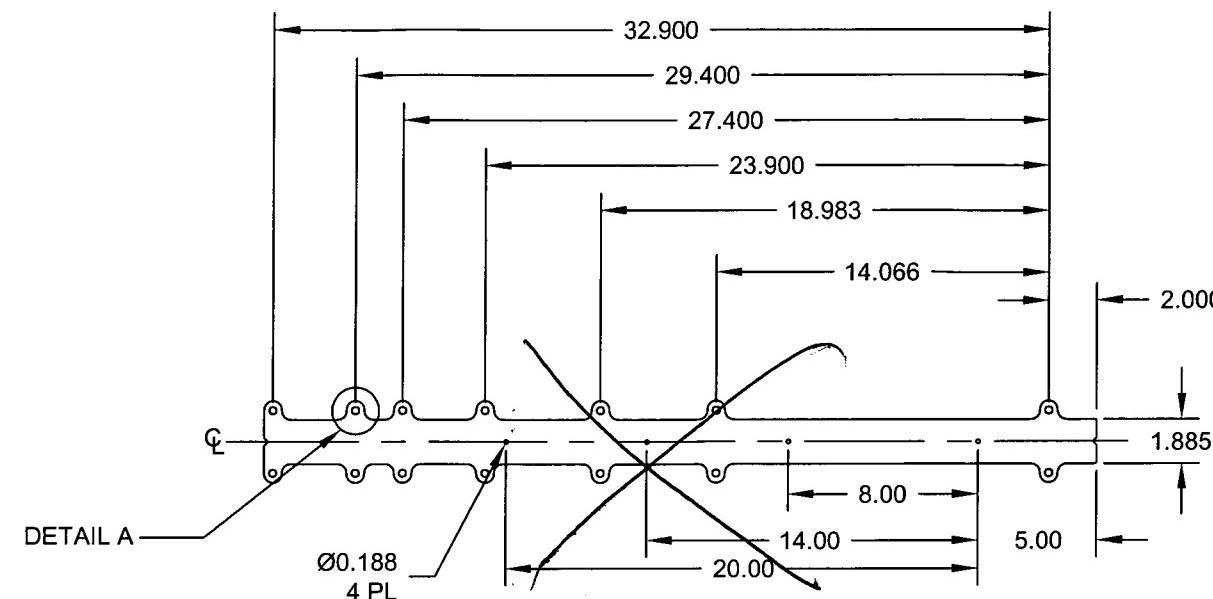


✓ 08-05-21

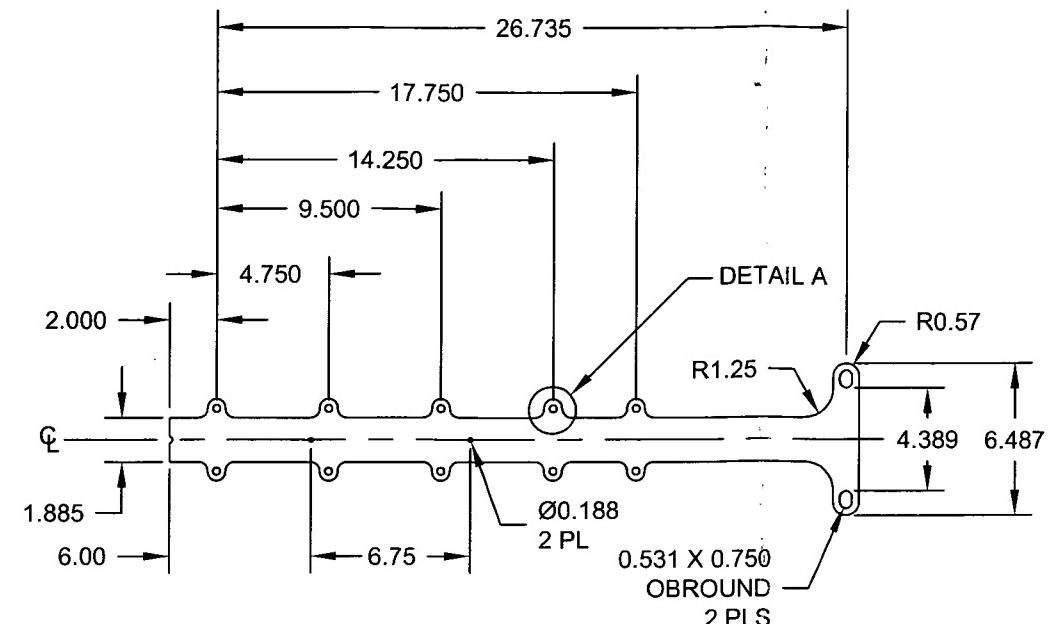
POSITIVE RECALL  
EFFECTIVE 08.05.20 AUTH 11  
RELEASED DATE

8 7 6 5 4 3 2 1

D

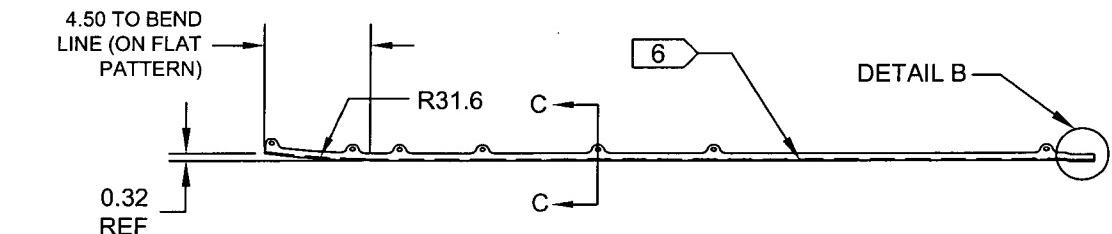


D3793-1F FLAT PATTERN



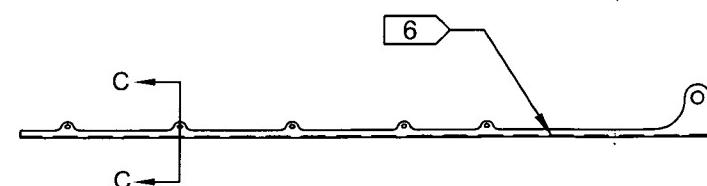
D3793-3F FLAT PATTERN

C



D3793-1 BEND DETAIL

(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL

(MAKE FROM D3793-3F)

**PRELIMINARY ISSUE**

REV 08.05.14

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	1	DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC	
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8

7

6

5

4

3

2

1

A

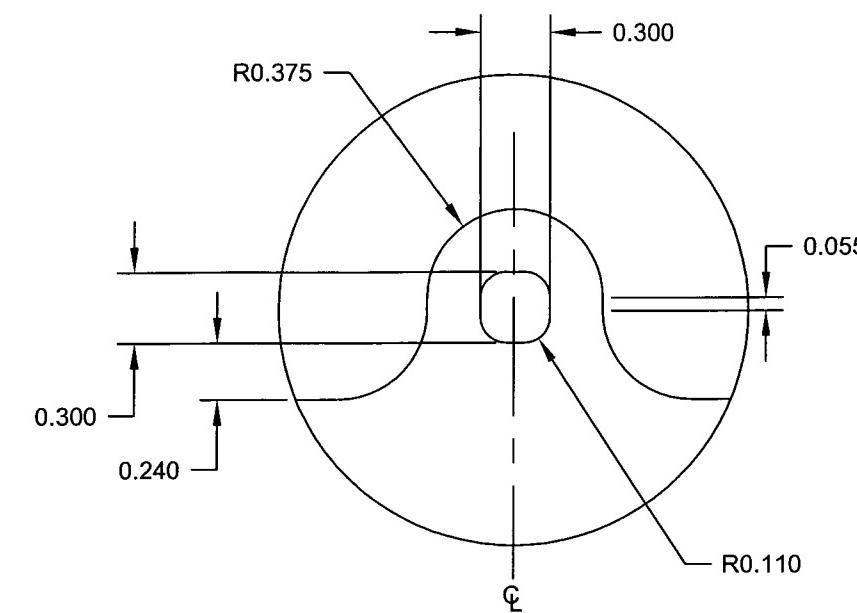
D

C

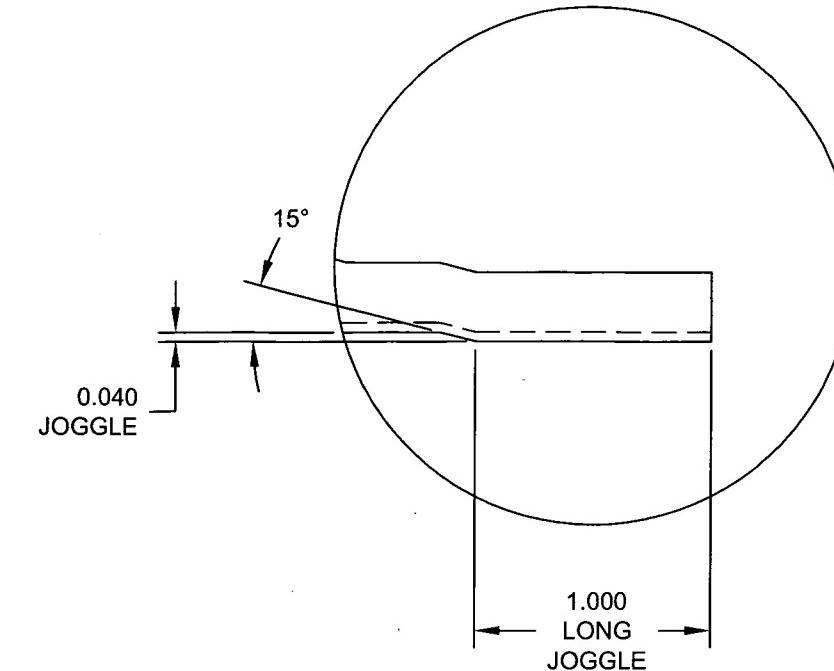
B

8 7 6 5 4 3 2 1

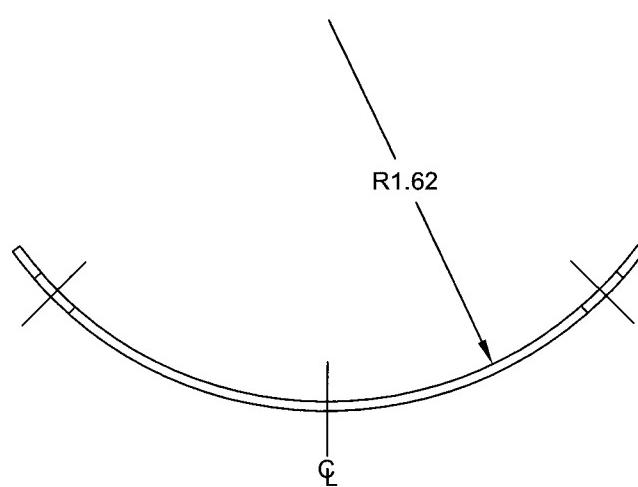
D



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X



**SECTION C-C**  
SCALE 10X

*P&J 06.05.20*

DESIGN		<b>DART AEROSPACE USA, INC</b>
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3793 SHEET 2 OF 2
APPROVED		TITLE
DE APPR.		WEARSHOE
DATE	08.05.14	SCALE NTS
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8 7 6 5 4 3 2 1

D

C

B

A

1